

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END PLATE
Job Number	: 27591		
Estimate Number	: 10547		
P.O. Number	: NIA	Part Number	: D30671
This Issue	: 6/16/2006 S.O. No. : NIA	Drawing Number	: D3067 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/15/2006 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 26411	Material	: NIA
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/30/2006
Checked & Approved By	: _____	Qty:	167
Comment	: Est:03.01.21 Remove step 6 (Deburr) KJ	Um:	Each

Job Number:

Form: rprocess

Date: Friday, 6/16/2006 1:41:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 27591

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

06-06-27 166

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/27 166

Job Completion



U 06-06-27

Date: Thursday, 6/15/2006 1:56:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END PLATE
Job Number	: 27591		
Estimate Number	: 10547		
P.O. Number	:	Part Number	: D30671
This Issue	: 6/15/2006 S.O. No. :	Drawing Number	: D3067 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/15/2006 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 26411	Material	:
Written By	:	Due Date	: 6/30/2006 Qty: 160 Um: Each
Checked & Approved By	: <i>HA 06.06.15</i>		
Comment	: Est:03.01.11 Remove step 6 (Deburr) KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.0656 sf(s)/Unit Total : 10.5000 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 (QQ-A-250/8)

M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)

Batch:

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blanks 2.750" x 3.030" +/-0.005

Grain along 2.750"

N/A

3.0	HAAS1 <i>Water Jet.</i>	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Cut Machine per folio FA183 and Dwg D3067

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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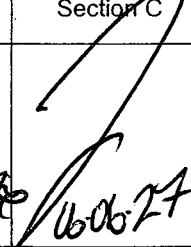

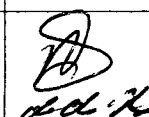
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/20	5	1 piece was scrap out of Tolerance		Scrap & destroy	SB 06/06/20	 06/06/20		 06/06/20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/20

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:56:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 27591

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3067

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO NEXT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

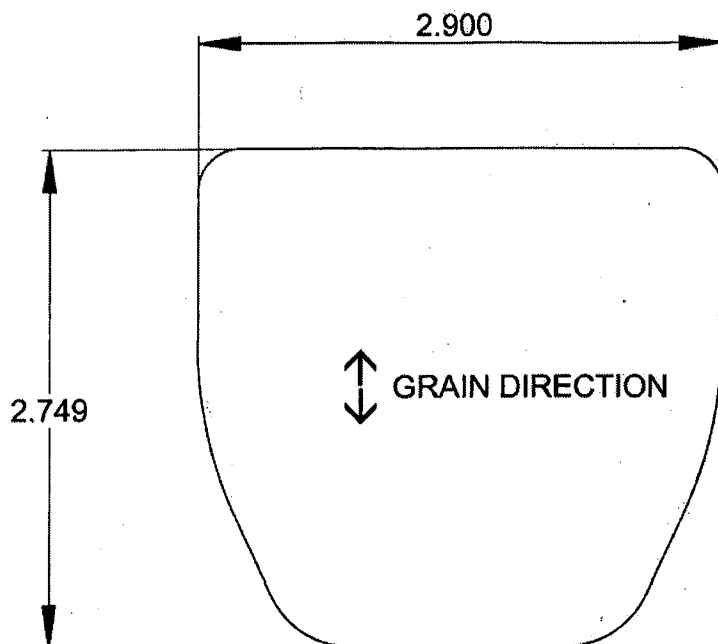
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

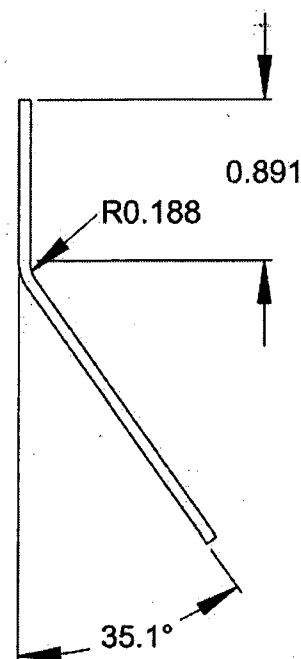


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK

- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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